

Work Order ID 48239

Friday, June 26, 2009 8:57:18 AM



Page 1

Item ID: D3040-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 7/15/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3040	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3041 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

Quality Control

0.00

0.00

WB 9-7-2
m. 04/07/06 Deburr
WB 9-7-2

(6X) (56)
(6X) (56)

=> 802/07/06 ^{counts} (X56)

W/O: 48239		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3040-1 PAR #: N/P Fault Category: Sm FAB NCR: Yes No DQA: / Date: 09.07.08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 09.07.09

NCR: 48239		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/06	25 100	Forma Qty ① with cut out on top & R.C machine malfunction.	<u>/</u> 09/07/06	Scrap & No-Replace Qty 1	<u>S</u> 09/07/06	<u>/</u> 09/07/06	<u>/</u> 09/07/06	<u>S</u> 09/07/06

NOTE: Date & initial all entries

Work Order ID 48239

Friday, June 26, 2009 8:57:18 AM



Page 2

Item ID: D3040-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 7/15/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

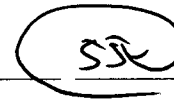
Memo

0.00

Packaging

9/7/6

50



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/08 MFmf
09-07-08

Picklist Print

Page 1

Friday, June 26, 2009 8:57:17 AM

Work Order ID: 48239

Parent Item: D3040-1RevB

Parent Item Name: Mounting Lug



Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased	No			100	f	0.0000	14.9095			
 M 106652 B 9-7-2 												
6061-T6 Bar .178 x 4.00												

Date: Thursday, 28/05/2009 9:11:48 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 48239	
Estimate Number : 11534	
P.O. Number :	Part Number : D30401
This Issue : 28/05/2009 S.O. No. :	Drawing Number : D3040 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 46849	Material :
Written By :	Due Date : 04/06/2009 Qty: 40 Um: Each
Checked & Approved By : <u>JLO 09.05.28</u>	
Comment : Est:B 01.11.08 Revised Step 2 and Added Inspection Level 21 S M Est Rev:C Now on WaterJet 07-03-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6B0187X04000	6061-T6 Bar .178 x 4.00
-----	--------------------	-------------------------



Comment: Qty.: 0.3718 f(s)/Unit Total : 14.8722 f(s)
 6061-T6 Bar .178" x 4.0"
 Material: 6061-T6 alum plate 0.188" thick

Batch: 106657 HB 9-7-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3041
 Dwg Rev: B
 Prog Rev: B

HB 9-7-2

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-7-2

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 05/07/06 456

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:48 AM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 48239

Part Number: D30401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

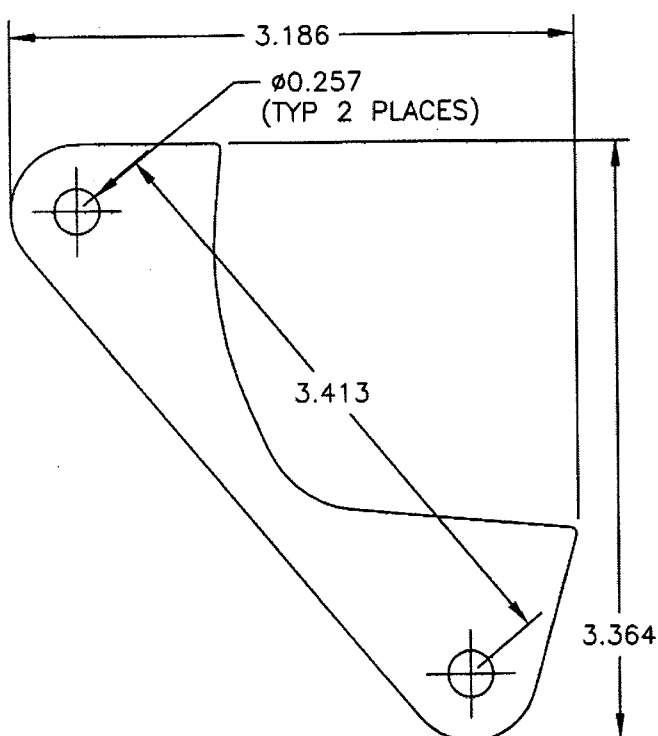
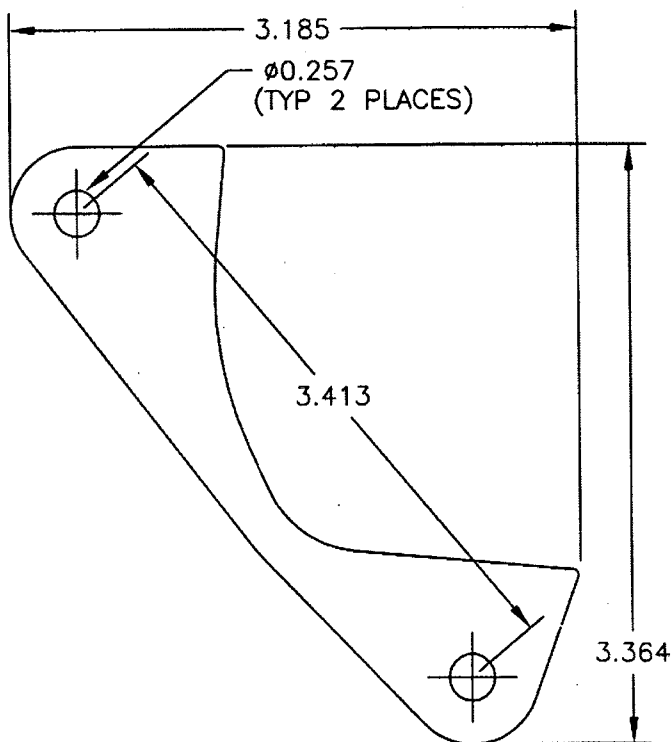
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
01.09.07

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3040	REV. B SHEET 1 OF 1
DATE 01.09.04		TITLE MOUNTING LUG	SCALE 1:1
A	01.06.27	NEW ISSUE	
B	01.09.04	CHANGED PROFILE 5 DEGREES	

D3040-1D3040-3**NOTES**

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK (REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
THICK CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48239

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